

Work Order ID 146401

Wednesday, August 03, 2016 1:32:03 PM

146401

Page 1

Item ID: D3916-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib Assembly

Start Date: 6/16/2016 Start Qty: 10.00

10

Required Date: 6/21/2016 Req'd Qty: 10.00

10

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: AUG 03 2016

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3916

A

100

0.00

100

Large Fab

Large Fab

Memo

0.83

1- Cut tube 50"

2- Bend tube with manuel pipe bender as per DT9567

*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***

3- Trim access tube material to finish size as per dwg D3916

4- Drill and chamfer holes as per dwg D3916-1 using DT9605

10 9 160803

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Quality Control

Memo

0.00

DAS
43
9-89

10x

AUG 08 2016

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Run Start *NR1*
Stop *NR2*

[illegible]

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Accept

N900040100Setup Start ***NS1***

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Start Date: 6/16/2016 Start Qty: 10.00

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Cust Item ID:

Required Date: 6/21/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>WIP</i>	0.00							
130						<i>4</i>	<i>CC</i>	<i>16-9-7</i>	
Packaging	Memo	0.02							
Packaging	LOCATION: WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.17							
Quality Control									

DAS
21
9-89

SEP 07 2016

DAS
21
9-89

SEP 07 2016

Picklist Print

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Work Order ID: 146401

146401

Parent Item: D3916-041

D3916-041

Parent Item Name: Rib Assembly

Start Date: 6/16/2016

Required Date: 6/21/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1		Manufactured	No			100	Each	79.0000	7	70			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D3759-1

Bushing

CC 16-9-7

Location

WA004

145615

147322

Loc Qty

79

36

43

Loc Code

~~B149531~~

B149531

28

M304TS0.750W.049

Purchased

No

100

f

723.8340

4.166

43.85263

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

44 CP 16-08-03

Location

WA004

M134506

M134526

M134680

M134940

M135226

Loc Qty

723.834

10

45.834

80

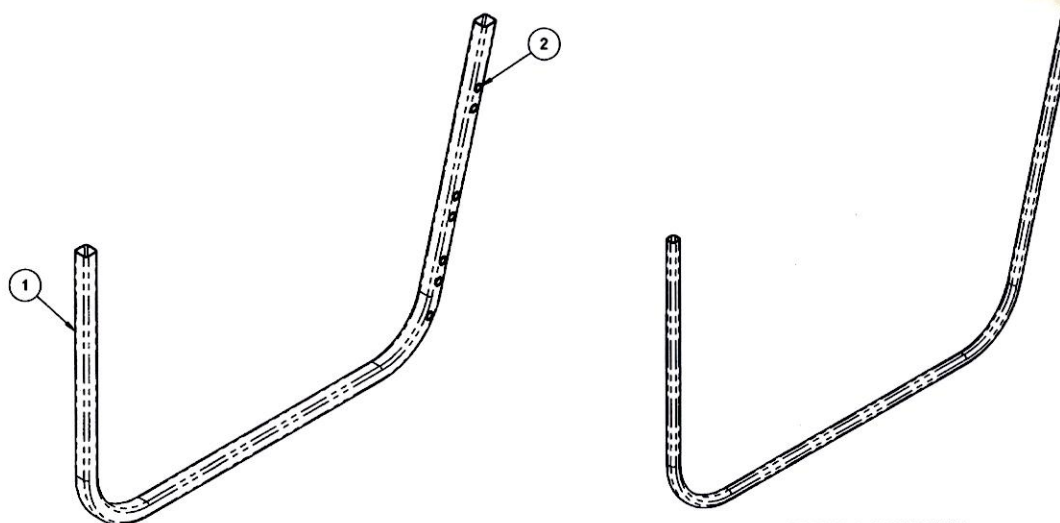
388

200

Loc Code

44

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY

D3916-5 LIGHT RIB

146 401 MLS
16-05-18

OK 10.12.21

UNDER REVIEW

ADDITION OF HOLE + BUSHING
on D3916-041-1 RIBS.

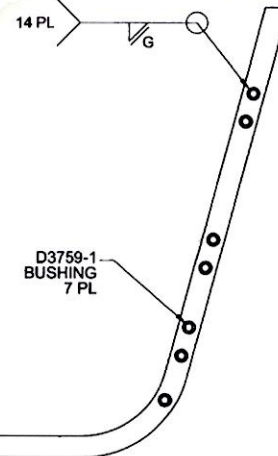
RELEASED
2010-03-12
JWP

A NEW ISSUE		JPH 10.03.04	
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3916	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

D3916-041 RIB ASSY

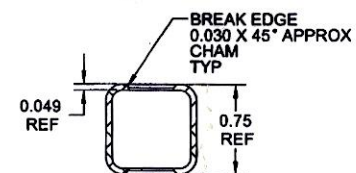
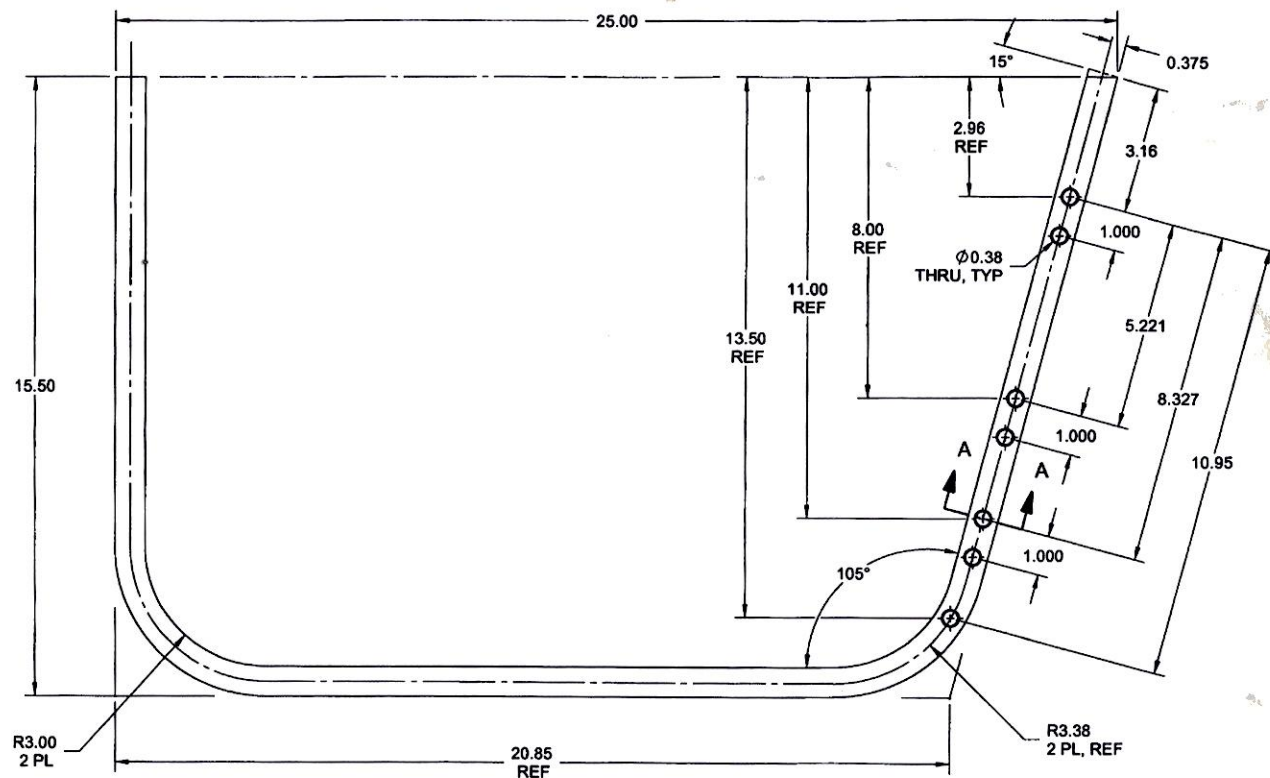
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004



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2010-03-12
MP

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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SECTION A-A

9 D3916-1 RIB

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

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DRAWN	JPH		
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